

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14390	39/50
3	Pallet Die No.		V.T.L. n/c Shop	By H. Lark 9810
4	Die Category	Drg. No.	14286 (3.0) n/c	
5	Out Side Diameter	Drg. No.	Exch. side	
6	Inside Diameter	Drg. No.	6.20 n/c, Step 0.02 812 n/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	5.20-12 n/c	
8	Grooves as per Drawing	Drg. No.	2.22 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13.68 ± 5 n/c 13.68 ± 5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		5.85 n/c	
13	Tapping Hole Diameter		n/c - Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/8/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter Sink Ravi 38
2	External Relief Dia	3.5 n/c	outside (3-3)	Inner
3	External Relief Depth		17 n/c	11 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnore	
6	Material Sent For Hardening On Date		22	3
Inspected By (Sign) & Date			Ravi 22/8/25	

Reviewed by (Engineer-CNC)

Manager-QA